

Date: Thursday, 11/29/2007 11:03:05 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE KIT FOR D206-642-511		
Job Number	36021		Part Number	K642 511		
Estimate Number	12893		Drawing Number	N/A		
P.O. Number	:		Project Number	N/A		
This Issue	11/29/2007	S.O. No. :	Drawing Revision	N/A		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : LANDING GEAR	Due Date	12/5/2007	Qty:	4
Previous Run	35716		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	Est Rev A 07.06.05 new issue EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GHW Kit

Batch:

B34923 3X B35599 1X 10

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

36150

10

5.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

34628

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36021		Part Number: K642 511
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D29321	206 Saddle Left side 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <i>(44)</i> Qty Part Number Description Batch 1 D2932-1 Saddle B34615 3x B347831x <i>(P)</i>
7.0	D29331	206 Saddle Left 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <i>(44)</i> Qty Part Number Description Batch 1 D2933-1 Saddle B34629 1x B34731 3x <i>(P)</i>
8.0	D2934	Saddle Spacer 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: <i>(44)</i> Qty Part Number Description Batch 2 D2934 Saddle Spacer B34630 <i>(P)</i>
9.0	D2935	Saddle Spacer 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: <i>(44)</i> Qty Part Number Description Batch 2 D2935 Saddle Spacer 34174 <i>(P)</i>
10.0	D29381	206 Saddle Left side 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <i>(44)</i> Qty Part Number Description Batch 1 D2938-1 Saddle B36890 <i>(P) 8/1/25 (8)</i>
11.0	D29391	206 Saddle Left side 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <i>(44)</i> Qty Part Number Description Batch 1 D2939-1 Saddle 34632 2x <i>(P) 8/1/25 (8)</i> <i>(P) 368912x SD</i> <i>B 368912x</i>

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36021		Part Number: K642 511
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	D33963	Inventory 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3396-3 Spacer 36336
13.0	D3407043	Tow Ring 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3407-043 Tow Ring B34011 3X B35510 1X
14.0	D34561	washer 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3456-1 Washer B25701 1X B33276 3X
15.0	D34571	Inventory 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3457-1 Washer M123403
16.0	AN3C35A	BOLT 
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Qty Part Number Description Batch 3 AN3C35A Bolt M105858
17.0	AN3C36A	BOLT 
		Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s) Pick: Qty Part Number Description Batch 9 AN3C36A Bolt M106041

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Job Number: 36021		Part Number: K642 511
Job Number:		
Seq. #:	Machine Or Operation:	Description :
18.0	AN3C41A 	BOLT 
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) Pick: Qty Part Number Description Batch 8 AN3C41A Bolt M106169		
19.0	AN4C6A 	Bolt 
Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s) Pick: Qty Part Number Description Batch 12 AN4C6A Bolt M104601 20 M102039 1X M105793 45X		
20.0	AN5C11A 	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) Pick: Qty Part Number Description Batch 8 AN5C11A Bolt M105792 4X M106303 25X		m106552 1X 
21.0	AN5C12A 	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch 4 AN5C12A Bolt M104755 15X M106316 10		
22.0	AN5C13A 	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch 4 AN5C13A Bolt M104989 15X		m106516 1X 
23.0	AN5C15A 	Bolt 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN5C15A Bolt M105625		

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 36021		Part Number: K642 511
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
24.0	AN5C32A 	 Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 AN5C32A Bolt M105746
25.0	AN5C34A 	 Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 AN5C34A Bolt M105160
26.0	AN5C35A 	 Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN5C35A Bolt M18918
27.0	AN960C10L 	washer  Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s) Pick: Qty Part Number Description Batch 24 AN960C10L Washer M106552
28.0	AN960C416L 	WASHER  Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s) Pick: Qty Part Number Description Batch 24 AN960C416L Washer M105793

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 36021	Part Number: K642 511
Job Number:	
Seq. #: 29.0	Machine Or Operation: AN960C516L Description: WASHER
<i>(S)</i>	Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) Pick: Qty Part Number Description Batch 8 AN960C516L Washer <u>M1023347</u>
<i>(H)</i>	
30.0	MS210433 Description: Nut
<i>(S)</i>	Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s) Pick: Qty Part Number Description Batch 20 MS21043-3 Nut <u>M106516</u>
<i>(H)</i>	
31.0	MS210434 Description: Nut
<i>(S)</i>	Comment: Qty.: 13.0000 Each(s)/Unit Total : 52.0000 Each(s) Pick: Qty Part Number Description Batch 13 MS21043-4 Nut <u>M101390</u> 12X M106421 40X
<i>(H)</i>	
32.0	MS210435 Description: Nut
<i>(S)</i>	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch 4 MS21043-5Nut <u>M10535</u> 10X M105730 6X
<i>(H)</i>	
33.0	NAS1515H3L Description: WASHER
<i>(S)</i>	Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s) Pick: Qty Part Number Description Batch 24 NAS1515H3L Washer <u>M105793</u>
<i>(H)</i>	
34.0	NAS1515H4L Description: WASHER
<i>(S)</i>	Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s) Pick: Qty Part Number Description Batch 24 NAS1515H4L Washer <u>M105728</u>
<i>(H)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 28/01/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:			
Seq. #:	Machine Or Operation:	Description :	
	24 NAS1515H4L Washer		
35.0	NAS1515H5	Washer	
Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)			
Pick: <i>(+4)</i>			
Qty	Part Number	Description	Batch
16	NAS1515H5	Washer	M105792 SX M10654159
36.0	NAS1515H5L	WASHER	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)			
Pick: <i>(+4)</i>			
Qty	Part Number	Description	Batch
8	NAS1515H5L	Washer	M105782
37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
Comment: INSPECT 100% KITS FOR COMPLETENESS			
38.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1			
Identify and pack for shipping as per PPP K642-511 CHG003			
Location: _____			
39.0	QC21	FINAL INSPECTION/W/O RELEASE	
Comment: FINAL INSPECTION/W/O RELEASE			
Job Completion			

*BAC 33 APR 05  
JRT 36022  
PC 8/1/11 (+4)  
086128 (+4)  
8/1/28 50 (+4)  
D 8/1/29 (+4)  
in 2008/1/28  
W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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